

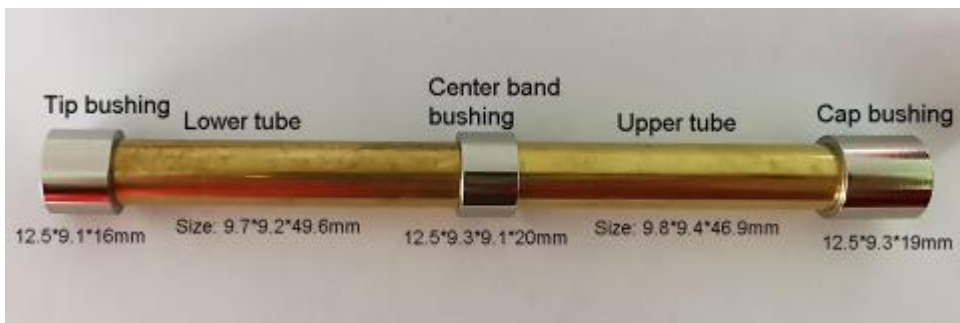


**Houtdraaiwerken-penkits**

## Honeybee & Sea fish pen Kits

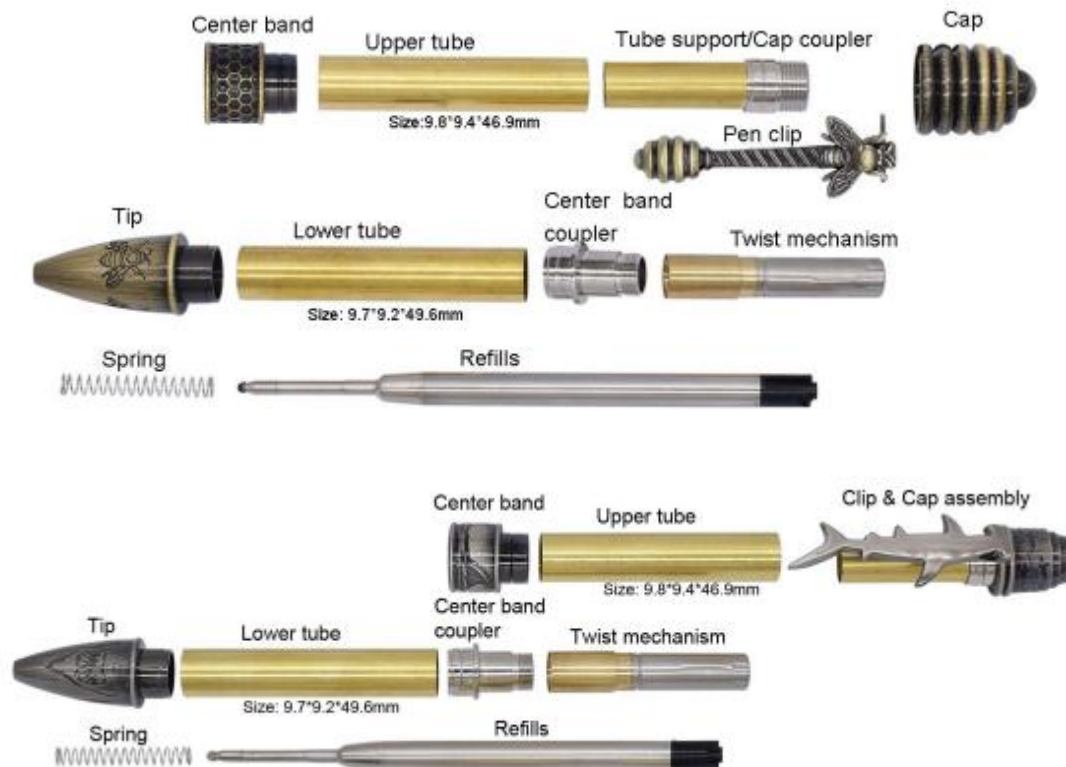
### Assembly Instructions

- 7mm pen mandrel
- Bushing Set BU 509
- 10mm & 25/64" Drill bit
- Minimum Blank size: 3/4" x 3/4" x 2-5/32" Preparing the Blanks:
- Prepare a master blank of at least 3/4" square. Cut two sections to the length of each tube. (Add 1/16" for trimming) Mark the center of each blank.
- Drill a centered hole lengthwise through each blank. Upper blank (shorter tube)—drill a 10mm hole through. Lower blank (longer tube)—drill a 25/64" hole through.
- Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center each tube lengthwise inside the blank.
- When glue dries, square the ends of each blank.



#### Turning the Blanks:

- Mount the bushings and blanks on the mandrel according to the Diagram above.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure. Pen



Assembly NOTE: Line up the components according to the above picture.

- Press the tip into one end of the lower tube (longer tube)
- Press the center band coupler into the opposite end of the lower tube.
- Remove the protector off the refill, insert the spring over and drop into the opening at the center band coupler.
- Screw the twist mechanism over the refill end.
- Press the center band into the end of the upper tube(shorter tube)
- Press the tube support/ cap coupler into the opposite end of the upper tube.
- Put the pen clip on the cap coupler, then screw the cap over the cap coupler.
- Engage both ends to close the gap in the center.
- The pen operates by twisting the ends to extend or retract the refill.

Be careful as I have indicated in the photo that you do not push the upper plunger further than what I have indicated with the arrow. If you push it in too far, the clip will not clamp properly and there will be movement in it. Also, the top part of the pen will not fit properly. If you accidentally press it too far, tap it back slightly from the inside.

